: BACK LEG FITTING

: D37641

: N/A

: B

. D3764 REV B

Date: User

Tuesday, 15/07/2008 9:14:17 AM

Julie Lecocq

## **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 40481

**Estimate Number** 

: 13293

P.O. Number

This Issue

: 15/07/2008

: NC Prsht Rev.

: 11 First Issue

: 39109 **Previous Run** 

: MACHINED PARTS Type ·

**Drawing Number Project Number** 

**Drawing Name** 

Part Number

**Drawing Revision** 

Material

: 30/07/2008 **Due Date** 

Qty:

Checked & Approved By

Written By

Comment

: Est Rev:A

New Issue 08-05-01 JLM Verified By:EC

**Additional Product** 

Job Number:



Seq. #:

1.0

3.0

Machine Or Operation:

Description:

Total:

M6061T6B1500X02000

6061-T6 Bar 1.5 x 2.0

Comment: Qty.: 0.2625 f(s)/Unit

6061-T6 Bar 1.5 x 2,0 Batch:

1.0500 f(s)

BAND SAW 2.0

BAND SAW



Comment: BAND SAW

Cut blank 2.95" long

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA741 Rev: AA & Dwg D3764Rev:

2-Deburr per dwg D3764

INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK





## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No: D3764-) PAR #: Or OdyFault Category: Prod Res Cardindo NCR: Yes No DQA: Date: 08/07/29

NCR: 4048 | WORK ORDER NON-CONFORMANCE (NCR)

DATE STEP | Description of NC | Corrective Action | Section B | Sign & Date | Chief Eng | C

	Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Tuesday, 15/07/2008 9:14:17 AM Date: 1 Julie Lecocq User: **Process Sheet** Drawing Name: BACK LEG FITTING Cwstomer: CU-DAR001 Dart Helicopters Services Part Number: D37641 Job Number: 40481 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 7.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 8.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## **Dart Aerospace Ltd**

Dail AC	iuspace	Liu								
W/O:			W	ORK ORDER CHAI	NGES					
DATE	STEP	PROCEDURE CHANGE					Date (	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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₹ Part No	:	PAR #:	_ Fault Cate	gory:	NCI	R: Yes N	o DQA:		Date:	
						QA: N/C	Closed:		_ Date:	
NCR:		W	ORK ORD	ER NON-CONFOR	MANCE	(NCR)		•		101111111111111111111111111111111111111
DATÉ	STEP	Description of NC	Corrective Action Section B				Verification		Approval	Approval
DATE	SIEP	Section A	Initial Chief 🗐 g	Action Description Chief Eng	on .	Sign & Date	Section C	Chief Eng	QC Inspector	
						:				
		:								

NOTE: Date & initial all entries

 $\bigcirc$ Ø0.323 THRU R0.43 0.600 Ø1.265<sup>+0.010</sup><sub>-0.000</sub> Ø1.010<sup>+0.010</sup><sub>-0.000</sub> Ø0.201 B 1.45 0.725 SHOP COPY R0.55 RETURN TO 0.605 1.370 INGINEERING UNCONTROLLED COT SUBJECT TO AMENDMEN 2.71 WITHOUT NOTICE WORK ORDER 40 / 8 **D3764-1 BACK LEG FITTING** CHANGE HOLE SIZE TO 0.201 08.06.10 NEW ISSUE 08.06.04 HS REV. DESCRIPTION DATE DESIGN HS DART AEROSPACE LTD NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PEN FOR OTHERWISE NOTED DRAWN HS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3764 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE 4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.13 lbs **BACK LEG FITTING** DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD
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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT DATE 08.06.10

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DART AEROSPACE LTD	Work Order: HOHR
BAILT ALL COLLEGE	
Description: back lea titing	Part Number: \\3+64-
the care is a mining	
Inspection Dwg:\\3764 . Rev: 3	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	·	Dimension	•		Inspection	
600	+ .010	600				
01.010	+ .010 + .010	1.013				
Ø1.265		1.2665	/			
10°	+ .5°	10°				
1.20	± ·030	1.201	/_			
Ø.323	1-006 	-324				
0.201	_ C'	,201	/			
1.45	+ .030	1.450	/			
. 725	7.010	. 724				
.605	+ .010	-606	/			
2.71	+ -030	2.710	/_			
1.370	010	1.372		•		
					,	
: :						
7.00						

Measured by:	7.L	Audited by:		Prototype Approval:		Δ
Date: 08	107/18	Date: 08	/07/1Y	Date:	1/1	1,
	•		/ /			

Rev	Date	Change	Revised by	Approved
A:		New Issue	KJ/JLM	

